

Work Order ID 64166

Thursday, November 25, 2010 4:03:12 PM

PRELIMINARY ISSUE



Page 1

Item ID: D4298-001

Accept



Setup Start



Revision ID: PREI IM

Stop



Item Name: Chart Holder Assembly

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00

Customer:



Reference:

Approvals:

Process Plan:

M

Date: 10-11-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4298

PA1

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

SD 10/12/17

①

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64166

Thursday, November 25, 2010 4:03:12 PM



Page 2

Item ID: D4298-001

Accept



Setup Start

Revision ID: P⁰ELIM

Stop



Item Name: Chart Holder Assembly

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.11.29 AUTH JA

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, November 25, 2010 4:03:18 PM

Work Order ID: 64166

Parent Item: D4298-001

Parent Item Name: Chart Holder Assembly









Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.10.25 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4298-002  Plate Assembly		Manufactured	No		B 64165		Each	0.0000	1	1		SB 10/12/15	
D4298-003  Plate Assembly		Manufactured	No		B 64164		Each	0.0000	1	1		SB 10/12/15	
D4298-004  Fixing Bracket Assembly		Manufactured	No		B 64163		Each	0.0000	1	1		SB 10/12/15	
D4298-006  Machined Inner Assembly		Manufactured	No		B 64162		Each	0.0000	1	1		SB 10/12/15	
D4298-007  Machined Outer Assembly		Manufactured	No		B 64161		Each	0.0000	1	1		SB 10/12/15	
D4298-013  Hinge		Manufactured	No		B 64156		Each	0.0000	1	1		SB 10/12/15	
D4298-014  Hinge		Manufactured	No		B 64155		Each	0.0000	1	1		SB 10/12/15	
D4298-020  Knob		Manufactured	No		B 64150		Each	0.0000	2	2		SB 10/12/15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 25, 2010 4:03:18 PM

Work Order ID: 64166

Parent Item: D4298-001

Parent Item Name: Chart Holder Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

D4298-021	Manufactured	No	B 64149	Each	0.0000	1	1		SB 10/12/15
Machined Bolt									
D4298-022	Manufactured	No	B 64148	Each	0.0000	1	1		SB 10/12/15
Pin Topper									
D4298-023	Manufactured	No	B 64147 364749	Each	0.0000	1	1		SB 10/12/15
Pin									
MS171441	Purchased	No	M 116355	Each	0.0000	1	1		SB 10/12/15
Spring Pin									
MS20392-3C35	Purchased	No		Each	0.0000	1	1		SB 10/12/15
Pin, Straight Head									
MS24665-103	Purchased	No		Each	0.0000	1	1		SB 10/12/15
Cotter Pin									
MS24693-C246	Purchased	No		Each	0.0000	4	4		SB 10/12/15
Screw									
MS27039C1-09	Purchased	No		Each	49.0000	3	3		
SCREW									

Location

Loc Qty

Loc Code

ST293

49

17831

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 25, 2010 4:03:18 PM

Work Order ID: 64166



Parent Item: D4298-001



Parent Item Name: Chart Holder Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00



NAS1149D0332J

Purchased

No

Each

343.0000

3

3



Washer

Location

Loc Qty

Loc Code

ST298

343

114348

1

114884

161

116169

181

M 116 290

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

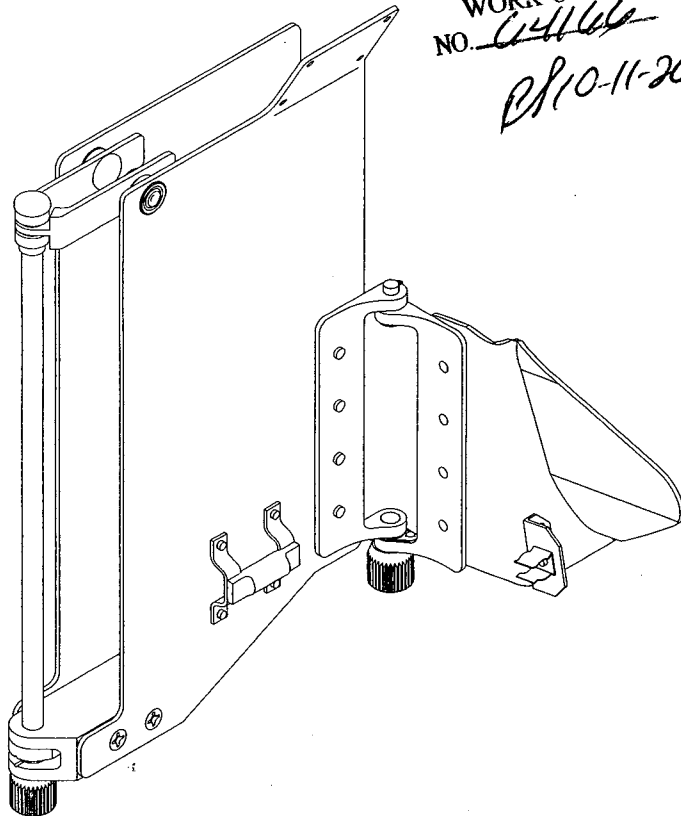
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *04466*

0810-11-26



REVISION					
LETTER	DRFTSMN	DATE	DESCRIPTION	APPROVED	DATE
IR	DNN	9/8/10	INITIAL RELEASE.		
A	DNN	11/12/10	MAT'L CHG. FOR ITEMS 8 THRU 20; CHG. GRIP ON 20; UPDATED P/N'S.		

			4			37	AN426AD4-()	RIVET						
			4			36	AN426AD3-()	RIVET						
			1			35		C-CLIP						
		2				34	MS27980-6B	SOCKET, SNAP FASTENER						
		2				33	MS27980-1B	BUTTON, SNAP FASTENER						
			1	1		32	MS27980-9B	POST, SNAP FASTENER						
			1	1		31	MS27980-7B	STUD, SNAP FASTENER						
					4	30	MS24693-C246	SCREW						
					1	29	MS171441	PIN, SPRING				(ALT P/N NAS561C2-13)		
					1	28	MS24665-103	COTTER PIN						
					1	27	MS20392-3C15	PIN, STRAIGHT HEADED						
					3	26	NAS1149D0332J	WASHER						
					3	25	MS27039C1-09	SCREW						
1	1		1	1		24	-024	SERRATED ADJUSTMENT WASHER		STAINLESS STEEL				
					1	23	-023	PIN		STAINLESS STEEL				
		1				22	-022	PIN TOPPER		STAINLESS STEEL				
					1	21	-021	MACHINE BOLT		STAINLESS STEEL				
					2	20	-020	KNOB		6061-T6 ALUM.				
1						19	-019	MACHINED OUTER		6061-T6 ALUM.				
	1					18	-018	MACHINED INNER		6061-T6 ALUM.				
					2	17	-017	CLIP STOP MOUNT		6061-T6 ALUM.				
					1	16	-016	CLIP STOP		6061-T6 ALUM.				
		1				15	-015	CLIP ANGLE	.050	6061-T6 ALUM.				
		1				14	-014	HINGE		6061-T6 ALUM.				
		1				13	-013	HINGE		6061-T6 ALUM.				
					1	12	-012	HINGE		6061-T6 ALUM.				
					1	11	-011	HINGE		6061-T6 ALUM.				
		1				10	-010	FIXING BRACKET	.093	LEXAN				
			1			9	-009	PLATE	.080	6061-T6 ALUM.				
					1	8	-008	PLATE	.080	6061-T6 ALUM.				
					1	7	-007	MACHINED OUTER SUB-ASSY						
					1	6	-006	MACHINED INNER SUB-ASSY						
					1	5	-005	HINGE SUB-ASSY						
					1	4	-004	FIXING BRACKET SUB-ASSY						
					1	3	-003	PLATE SUB-ASSY						
					1	2	-002	PLATE SUB-ASSY						
					1	1	-001	CHART HOLDER ASSY						
-007	-006	-005	-004	-003	-002	-001	ITEM NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC.	ZONE	
							NO. REQ'D PER ASSY.							

PROPRIETARY RIGHTS NOTICE
THESE DATA ARE PROPRIETARY TO ERA HELICOPTERS LLC. DISCLOSURE, REPRODUCTION OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA HELICOPTERS LLC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.

DASH
REV
PER
ASSY

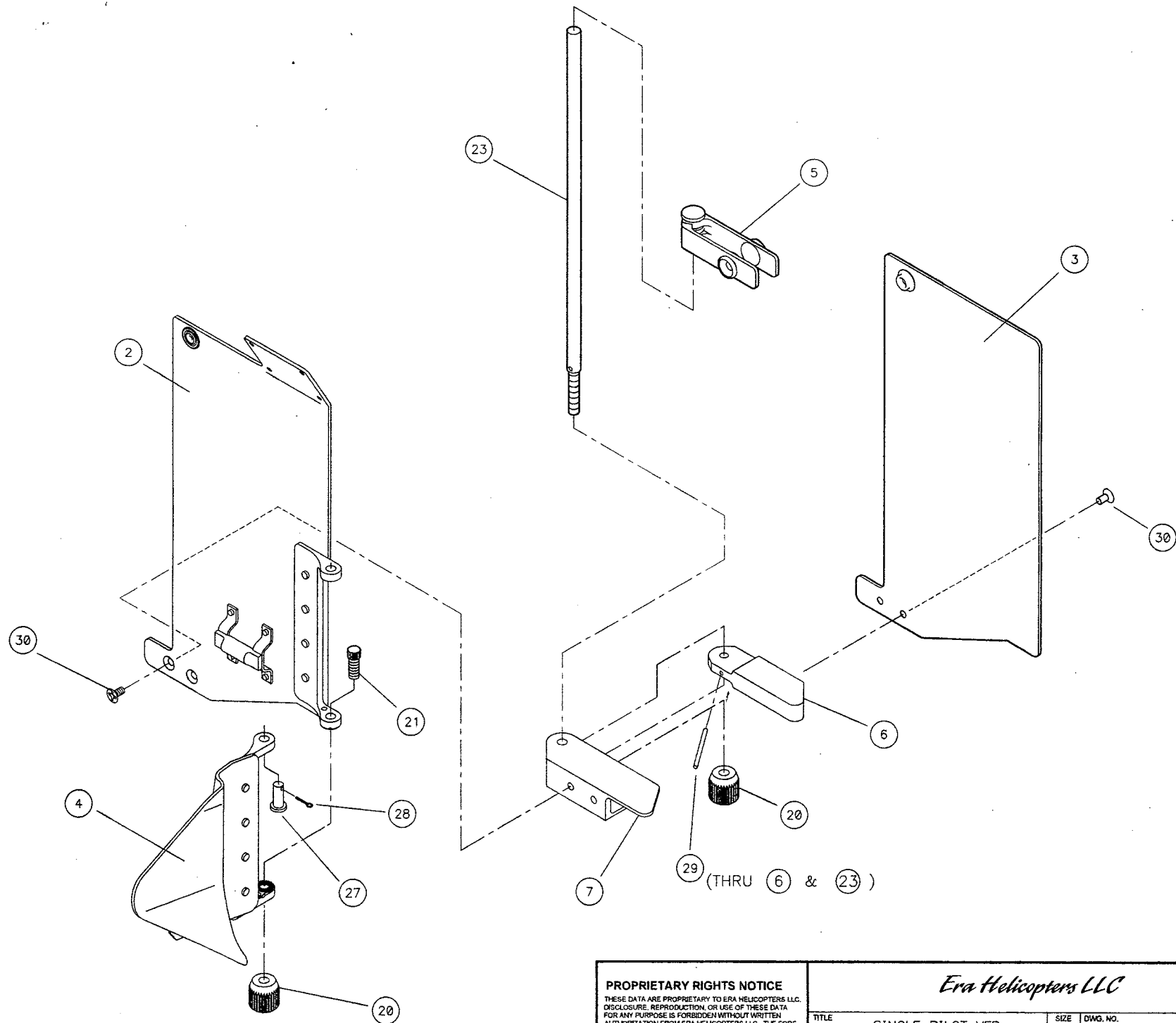
ASST. ASSEMBLY

MCL

UNLESS OTHERWISE SPECIFIED
X. ± 1
XX ± .03
XXX ± .010
ANGLES
± 1/2°

DRFTSMN
D. NELSON
9/8/10
CHECK
STRESS
PROJ.
ENGR.
HEAT TREAT
FINISH

TITLE
SINGLE PILOT VFR
CHART HOLDER, AW139
DWG. SIZE
C
SCALE
NONE
DWG. NO.
13939-1-290
SHT 1 OF 10
REV.
A
Era Helicopters LLC



PROPRIETARY RIGHTS NOTICE

THESE DATA ARE PROPRIETARY TO ERA HELICOPTERS LLC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA HELICOPTERS LLC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.

Era Helicopters LLC

TITLE		SIZE	DWG. NO.	REV.
SINGLE PILOT VFR CHART HOLDER, AW139		C	13939-1-290 SHT 2 OF 10	A

Eric Charbonneau

From: Domingue, Elvin [edomingue@erahelicopters.com]
Sent: December 17, 2010 10:24 AM
To: Nelson, David; 'echarbonneau@dartaero.com'
Subject: Re: washer addition

I agree David

Elvin Domingue
Sent from my BlackBerry Wireless Device

From: Nelson, David
To: 'Eric Charbonneau' <echarbonneau@dartaero.com>
Cc: Domingue, Elvin
Sent: Fri Dec 17 09:23:20 2010
Subject: FW: washer addition
Hi Eric,

That looks good. The added washer seems fine. The only other thing I would add is that all exposed hardware and surfaces would be painted.

But I'll let Elvin decide those issues.

I'll update and re-send the drawing with the knob depth fix, and add the other changes once approved.

Thanks,
David

From: Eric Charbonneau [<mailto:echarbonneau@dartaero.com>]
Sent: Friday, December 17, 2010 8:24 AM
To: Nelson, David
Subject: washer addition

Good morning David, for better function we added one AN960JD416 under both knob (see attached mark-up) please let me know if this is ok with and also I noticed on p9. of the drawing there's a typo on the depth of the threaded hole for the knob... should be 0.60" deep not 0.06". I Also attached a picture of the completed ass'y... looks pretty good.

Regards,

ERIC CHARBONNEAU
Production Engineering Coordinator

DART
aerospace

T(613) 632-5200
F(613) 632-1053
echarbonneau@dartaero.com



Please consider your environmental responsibility before printing this e-mail

The information contained in this transmission is privileged and confidential and intended only for the use of the individual or entity to whom it is addressed. If you are not the intended recipient, you are hereby notified that any distribution, copying, disclosure or taking of any action in reliance on the contents of this transmission is strictly prohibited and review by any individual other than the intended recipient shall not constitute waiver of privilege. If you have received this transmission in error, please notify me immediately and delete the original transmission.